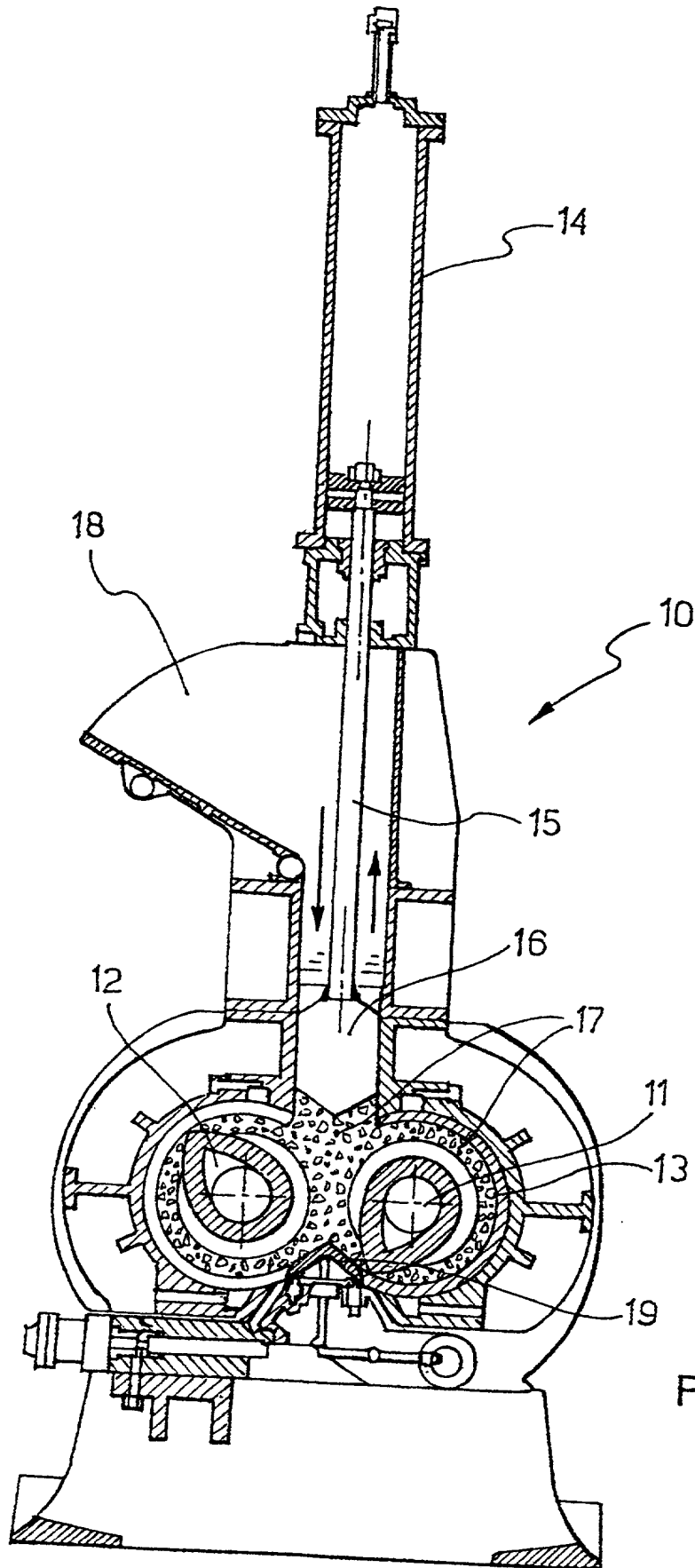


FIG.1

- 2/6 -



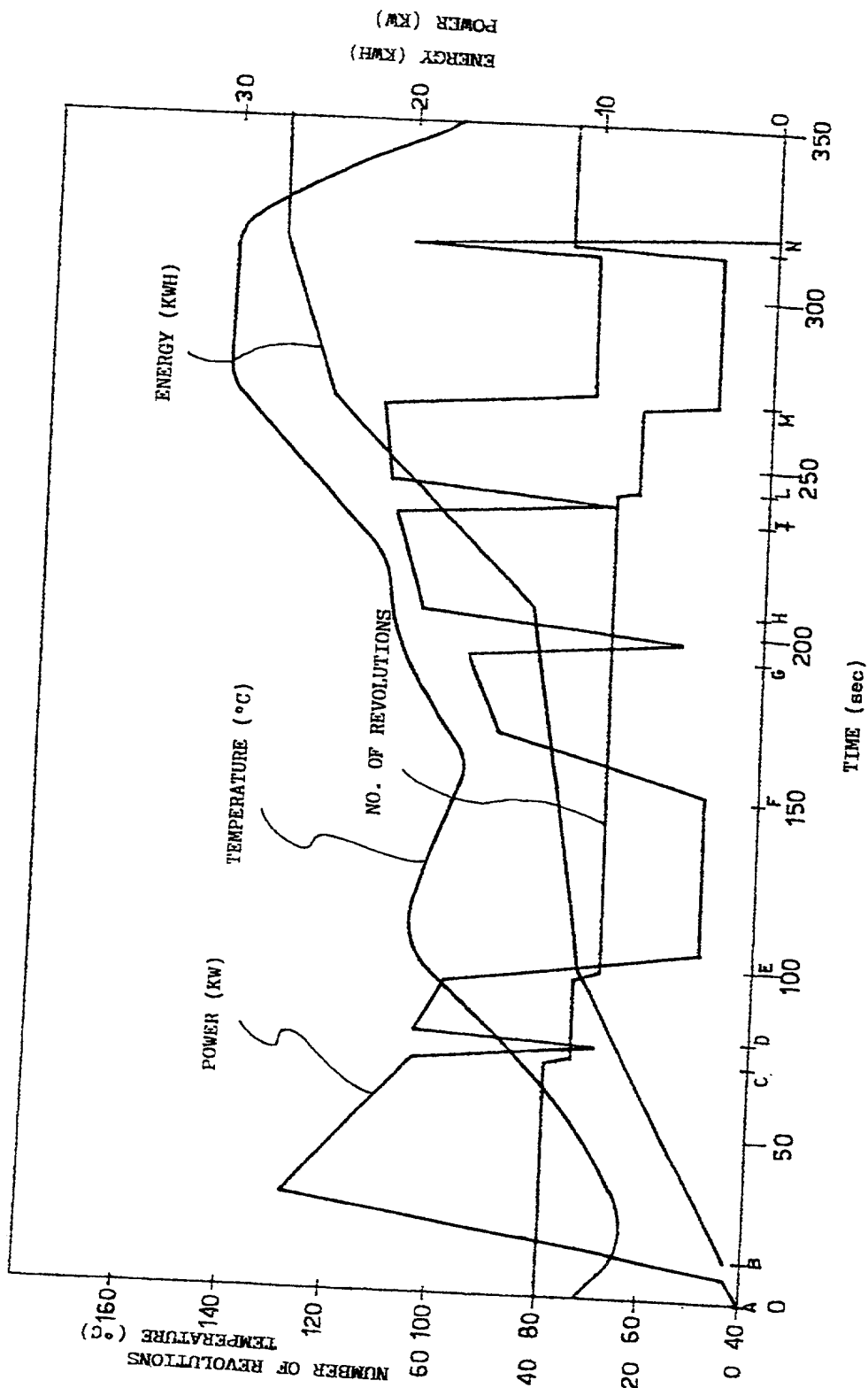


FIG. 3

PROCESS PARAMETERS	EXPECTED PROCESS PARAMETERS AND ASSOCIATED TOLERANCES				NON COMPLI- CY WEIGHING		EXAMPLE OF CHECK FOR COMPLIANCE OF PROCESS PARAMETERS OF A BATCH WITH PREDEFINED LIMIT VALUES				BASIS: TOTAL SCORE
	MIXTURE				MIXTURE				SCORE		
	STEP NO.	Set value	Tol.--	Tol.+	WEIGHT	STEP NO.	ACTUAL VALUE WITHIN LIMITS?	SCORE			
STEP TIME (sec)	H-I	30	0	6	5	H-I	48 sec	NO	5	0-2 : NORMAL	
PARTIAL TEMPERATURE (°C)	I	120	0	5	5	I	120 °C	YES	0		
PARTIAL ENERGY (KWH)	I	17.5	1.5	1.5	5	I	19.7 KWH	NO	5		
STEP TIME (sec)	L-M	25	5	5	7	L-M	42 sec	NO	7	21-30: DEFECTIVE 1st DEGREE	
PARTIAL TEMPERATURE (°C)	M	145	0	0	0	M	145 °C	YES	0		
PARTIAL ENERGY (KWH)	M	24.5	2.4	2.4	8	M	27.7 KWH	NO	8		
PARTIAL CYCLE TIME (sec)	N	315	45	125	10	N	470	NO	10	31-60: DEFECTIVE 2nd DEGREE	
TOTAL MIXING TIME (sec)	N	245	25	120	40	N	308	YES	0		
TOTAL ENERGY (KWH)	N	27.0	1.0	4.0	10	N	32.1	NO	10		
PARTIAL TEMPERATURE (°C)	N	145	4	4	10	N	144	YES	0	> 60 : REJECT	
					100				45	DEFECTIVE 2nd DEGREE	

Fig.4

REFERENCE CLASSIFICATION
≤ 6 min : NORMAL > 6 min / 9 min : DEFECTIVE 2 nd DEGREE > 9 min : REJECT

PROCESS PARAMETERS	DETECTED VALUE
MAINTENANCE TIME OF MIXTURE INSIDE THE EXTRUDER	11 min

► REJECT

FIG. 5

Fig. 6

